

Date: Thursday, 4/12/2007 9:34:21 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	HINGE BRACKET
Job Number	31791	Part Number	D28572
Estimate Number	10347	Drawing Number	D2857 REV B
P.O. Number	N/A	Project Number	N/A
This Issue	4/12/2007	S.O. No.	N/A
Prsht Rev.	NC	Type	MACHINED PARTS
First Issue	N/A	Material	N/A
Previous Run	30718	Due Date	5/10/2007
Written By	Qty: 24 Um: Each		
Checked & Approved By	7/07/04.12		
Comment	Est C 00.06.22 Removed P/O for powder coat EC Est D 06.03.30 Added level 8 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
Comment: Qty: 0.4594 f(s)/Unit Total: 11.0250 f(s) Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) (M6061T6B200001250) Batch M100451		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks 5.2"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2857-2		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/04/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/19	3	- 1 part scrap - operator forgot to retake "A" origin in begining of shift	<u>Initial</u> 07/04/19	- scrap + destroy	J.L 07/04/19	<input checked="" type="checkbox"/> 07/04/19	<input checked="" type="checkbox"/> 07/04/19	<input checked="" type="checkbox"/> 07/04/19

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 31791

Part Number: D28572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

an h 07/04/19

24

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

J.L 07/04/19

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid-etch and Alodine as per QSI 005 4.3

FL

07/04/23

24

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M-A

07/04/23

9.0 POWDER COATING POWDER COATING



M103 706

Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

FL

07-04-23

24

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EP 07/04/24

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/04/24 24

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

EP 07/04/04

Job Completion



u J.M.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31791
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857	Rev: <i>ATB</i>		Page 1 of 1

VE 04.07.12

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.309"	✓			
0.340	+/-0.010	,339"	✓			
1.110	+/-0.005	1.112"	✓			
1.790	+/-0.010	1.792"	✓			
1.320	+/-0.005	1.322"	✓			
2.000	+/-0.010	2.002"	✓			
Ø0.171	+0.005/-0.000	Ø,171"	✓			
Ø,340	± 0.010	,339"	✓			
0.147	+/-0.010	,153"	✓			
0.376	+/-0.010	,377"	✓			
0.126	+/-0.010	,122"	✓			
0.611	+/-0.010	,609"	✓			
0.063	+/-0.010	,060"	✓			
Ø0.340 4.000	± 0.010	4.002"	✓			
Ø0.166	+0.005/-0.000	Ø,167"	✓			
0.911	+/-0.010	,913"	✓			
0.600	+/-0.010	,599"	✓			
0.447	± 0.010	,447"	✓			
0.125	+/-0.010	,128"	✓			
0.150	+/-0.010	,149"	✓			

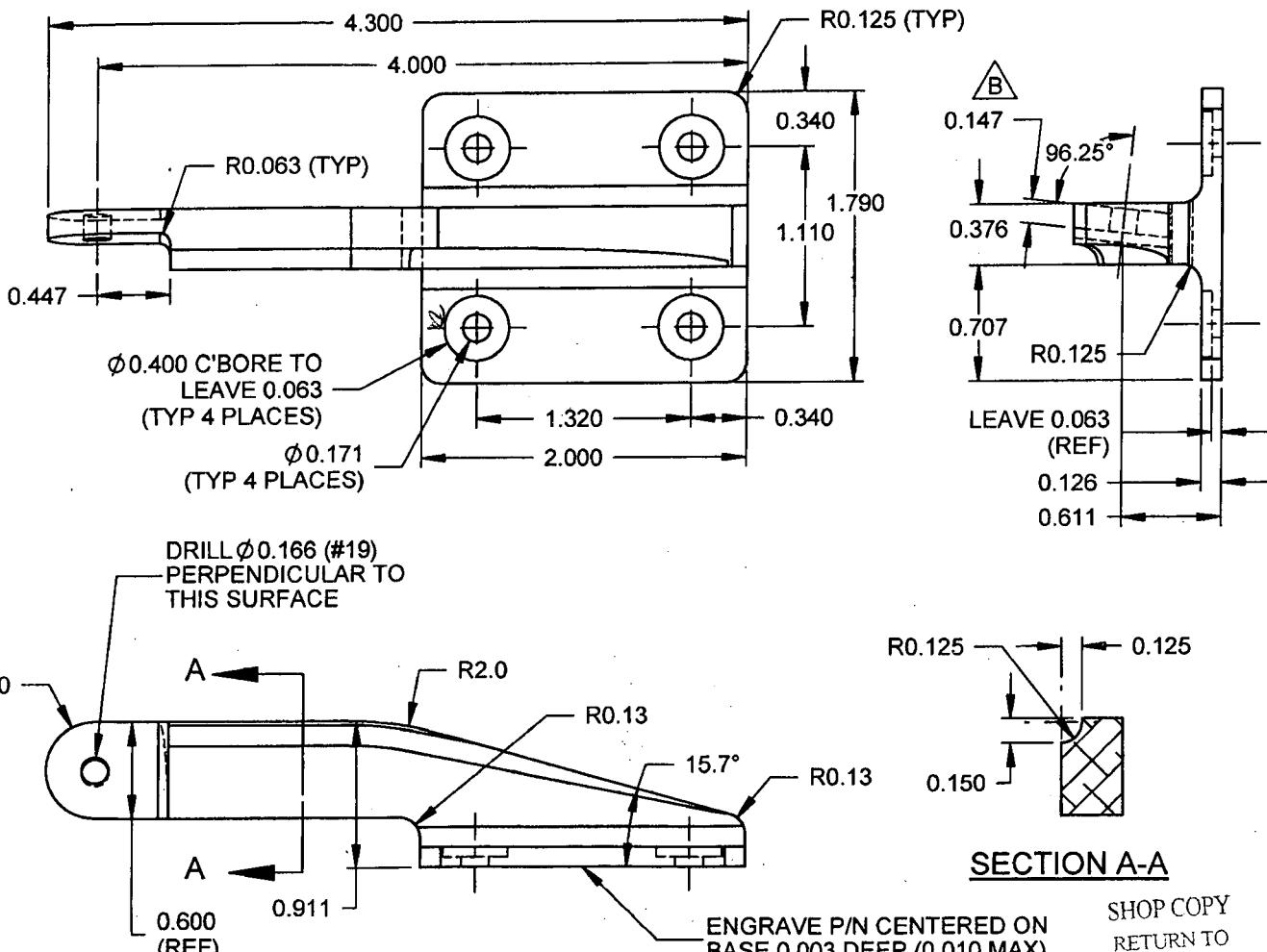
Measured by:	<i>J.F.</i>	Audited by:	<i>En</i>	Prototype Approval:	N/A
Date:	07/04/18	Date:	07/04/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM <i>En</i>	<i>Sh</i>

Sh

DART

DESIGN KE	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28		TITLE HINGE BRACKET	SCALE 1:1
REV A	DATE 98.12.14	DESCRIPTION NEW ISSUE	
REV B	DATE 06.08.28	DESCRIPTION ADD THICKNESS, REDRAW W/ SOLIDWORKS	

RELEASED
06-10-13

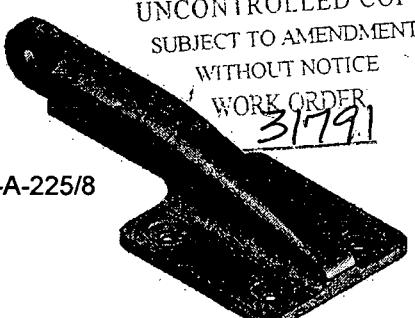
D2857-1 HINGE BRACKET
D2857-2 OPPOSITE

SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
31791

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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